



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Sdd 7927

D2842-041
Job Sheet 167724



Part No: D2842-041

Job Qty: 8 ea

Part Name: Step Assembly, LH, 206 Float



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/6/17

Job Tracking No:

Due Date: 12/6/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	12/2/17		0.00	0.00	Start Up Large Fab2		D.M.L 17-8-11
100	Large Fab	8 pcs	12/4/17		0.00	11.77	Large Fab 8		D.M.L 17-8-11
110	QC	8 pcs	12/4/17		0.00	0.00	QC6		DAL 38 9-88
120	Large Fab	8 pcs	12/5/17		0.00	11.77	Large Fab 2		17/11/23
130	QC	8 pcs	12/5/17		0.00	0.00	QC9		D 17/11/24
140	QC	8 pcs	12/5/17		0.00	0.00	QC5		D 17/11/24
150	HandFinish	8 pcs	12/5/17		0.00	2.96	HandFinish1		2017-11-29 JCL
160	QC	8 pcs	12/5/17		0.00	0.00	QC10		
170	Large Fab	8 pcs	12/5/17		0.00	11.77			S-L 12/4/17
180	QC	8 pcs	12/5/17		0.00	0.00	QC10		DAL 38 9-88
190	QC	8 pcs	12/5/17		0.00	0.00	QC5		DAL 38 9-88
191	HandFinish	8 pcs	12/5/17		0.00	2.96	HandFinish2		2017-12-04 JCL
200	Powdercoat	8 pcs	12/5/17		0.00	1.92	Powdercoat1		BR 17-12-6
210	QC	8 pcs	12/5/17		0.00	0.00	QC3		BEB 2017/12/06
220	HandFinish	8 pcs	12/6/17		0.00	2.96	HandFinish4		BEB 2017/12/07
230	QC	8 pcs	12/6/17		0.00	0.00	QC5		DAL 38 9-88
240	Packaging	8 pcs	12/6/17		0.00	0.00	Packaging3		DAL 21 9-89
250	QC21-SA	8 Ea	12/6/17		0.00	0.00	QC21		DEC 08 2017 PK001

Part Op 100 - 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8271 as per Dwg D2842
 Descriptions: ***DO NOT OPEN HOLES*** 3-Deburr and bevel ends for welding
 120 - 1-Weld one end cap and (2) lugs using Jig DT10038 as per Dwg D2842 2-Grind end cap weld flush 3- Open hole as per dwg and deburr(0.250")
 170 - 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.
 191 - ***Touch up step with alodine per qsi 005 prior to powder coat***
 200 - START TIME: _____ OVEN TEMPERATURE: 320° FINISH TIME: M138467
 220 - 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: M138423

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2622-120C	8	158	0	0
	D2734	16	14	0	0
	D3459-3	16	13	0	0
120-Large Fab	D2734 <i>F161519</i>	8	14	0	0
	D3459-1	16	14	0	0
	D3459-3	16	13	0	0
170-Large Fab	D2734 <i>S012001</i>	8	14	0	0
220-HandFinish <i>FM132317-10</i>	MS27039C1-07	24	89	0	0
	NAS1149C0332R	24	3,784	0	0
	NAS1329C3KB130	24	29	0	0
	NAS1515H3L	24	222	0	0

Part Specifications

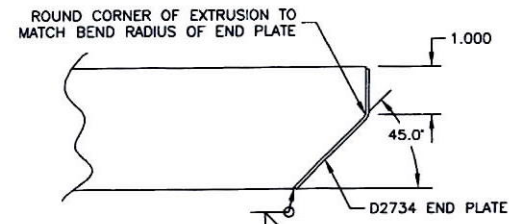
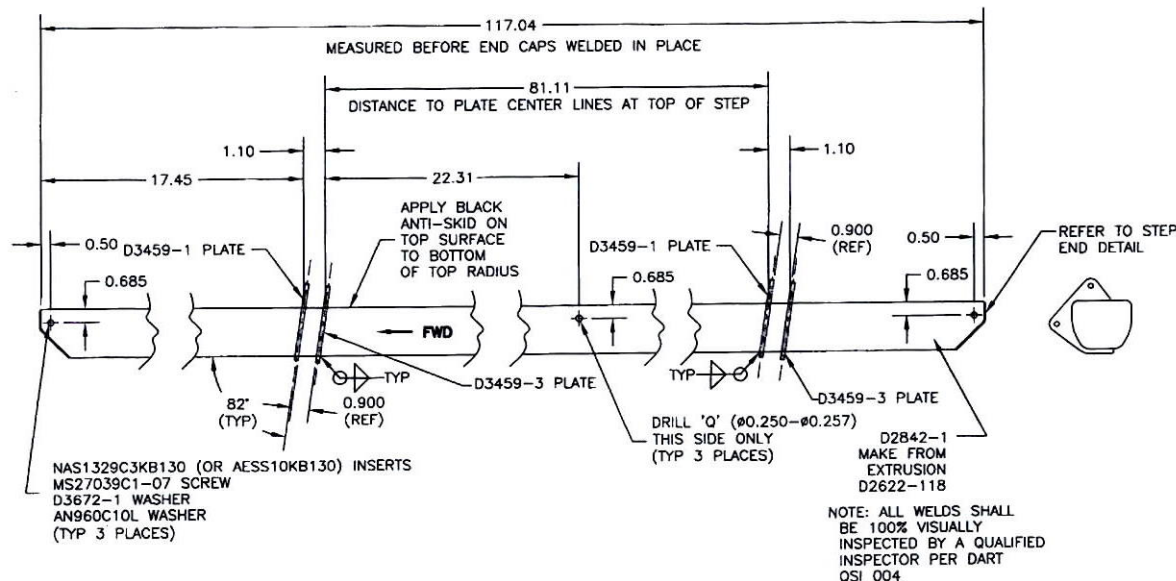
Specifications could not be found.

Plex 11/8/17 2:27 PM dart.poulin.mario

4 in 11 rock
D2734 (F164510)
 * D3459-1 (F146920 / F161777)
D3459-3 (F161689 / F146785)
 qty : 8
 qty : 14
 qty : 14
 } missing (2)

220 - Hand Finishing - NAS1329C3KB130 x15 - FM132767
 x5 - FM133483
 x4 - FM132803

Qty -041	Qty -042	Part Number	Description
X	X	D2842-041	LH FLOAT STEP ASSEMBLY
		D2842-042	RH FLOAT STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	D3672-1	WASHER
3	3	MS27039C1-07	SCREW
3	3	NAS1149C0332R	WASHER (AN960C10L)
3	3	NAS1329C3KB130	INSERT (or AESS10KB130)



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041 LH FLOAT STEP ASSEMBLY (SHOWN)
D2842-042 RH FLOAT STEP ASSEMBLY (OPPOSITE)

NOTES:

- 1) MATERIAL: MAKE FROM EXTRUSION D2622
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2842-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

RELEASED
2016-08-02
EON 16-620

C	ADD -043/-044 (FOR PHI) FORMATTED TO CURRENT STANDARD	DS	16.04.25
B	RE-DESIGN, ADD D3459-1/3	PH	98.10.13
A	NEW ISSUE	KE	98.10.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. C
MFG. APPR.	DD	D2842	SHEET 1 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		206/407 FLOAT STEP ASSEMBLY	NTS
DATE	16.04.25	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DART
AEROSPACE
S007927

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Step Assembly, LH, 206 Float

PART NO: D2842-041
Revision:
Operation: Large Fab
Change No:

Mfg Date: 11/08/17
Job No: 167724